

Work Order ID 67215

Thursday, March 10, 2011 2:39:41 PM



Page 1

Item ID: D2362-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Bracket

Start Date: 3/10/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 20.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

M

Date: 11-03-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2362

Rev E1

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA800 Rev: E1 & Dwg D2362 Rev: D ☐ 2-Deburr
per dwg D2362

B.A 11/04/14

20

0

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.A 11/04/14

20

0

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

amb 11/04/14

20

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo
Debur

0.00

0.00

140



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

M116964.

Memo

START TIME:

3:00 PM FINISH TIME:

10:00

OVEN TEMPERATURE:

10:30

0.00

0.00

20 BL 11-4-18.

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

20 0 11-4-15

W/O:		WORK ORDER CHANGES					
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Page 4

Thursday, March 10, 2011 2:39:41 PM

Item ID: D2362-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Support Bracket

Start Date: 3/10/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/19
MF
11-04-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Thursday, March 10, 2011 2:39:46 PM

Page 1

Work Order ID: 67215

Parent Item: D2362-3

Parent Item Name: Support Bracket



Start Date: 3/10/2011

Required Date: 3/18/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: G00.05.18 Added inspection level 8 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2397-3		Manufactured	No			100	Each	1.0000	1	20			
Rubber Cushion													

Location	Loc Qty	Loc Code
ST013	1	B 67593
38054	1	

D2265		Manufactured	No			160	Each	123.0000	1	20			
Step Bracket													

Location	Loc Qty	Loc Code
ST482	123	
37477	29	
44114	94	

D2397-1		Manufactured	No			160	Each	2.0000	1	20			
Rubber Cushion													

Location	Loc Qty	Loc Code
ST012	2	
38053	2	
B 67592		

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. *07215*
011-0350



RELEASED
98.12.14 KE

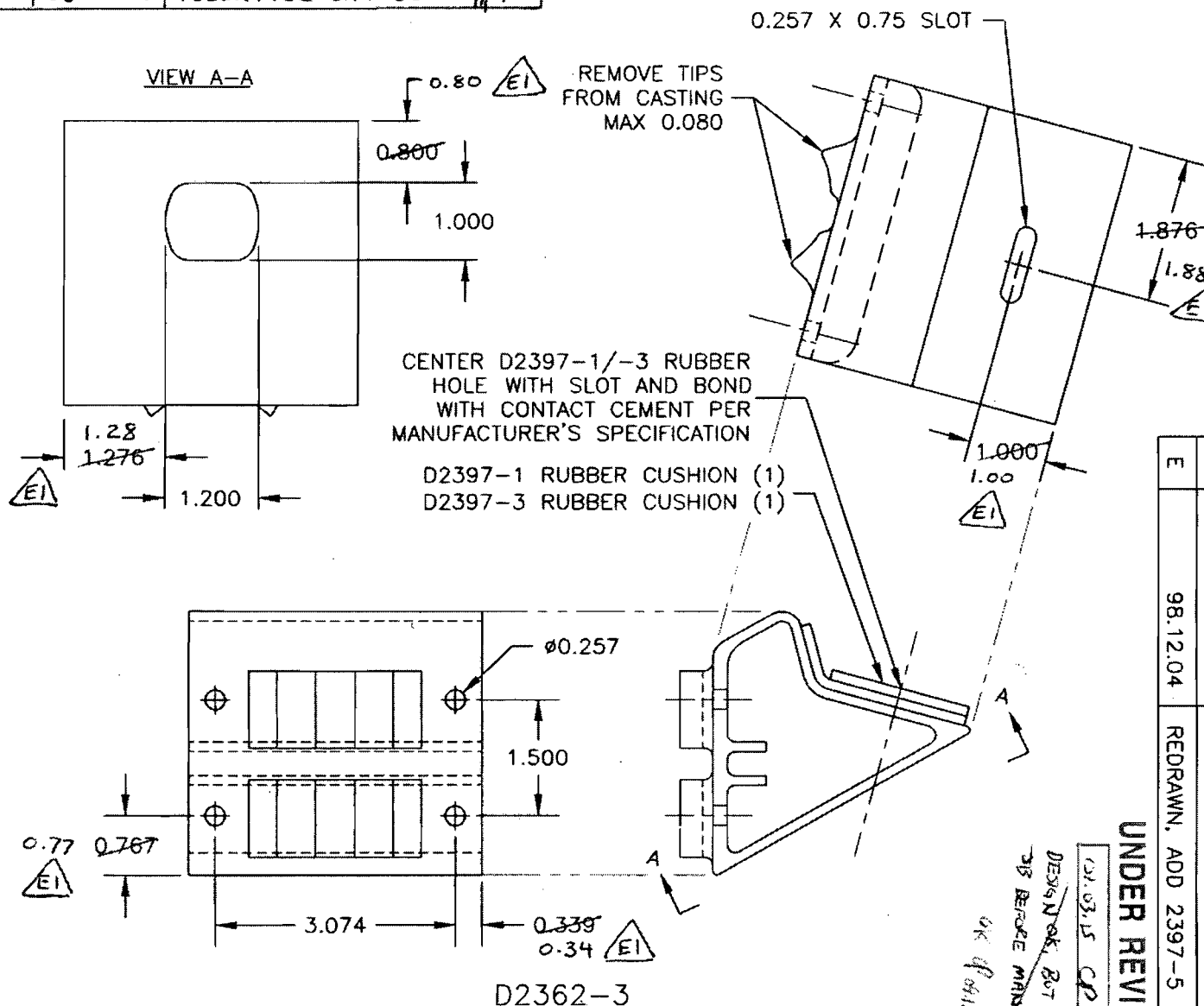
DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	<i>CP</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>KE</i>	<i>CP</i>	D2362
DATE	TITLE	SHEET 1 OF 3
98.12.04	STEP SUPPORT BRACKET	SCALE 1:2
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH
38 BEFORE MANUFACTURE
OK 01/11/04

EI 03.10.07 TOLERANCE CHANGE ~~RT~~



NOTES:

MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

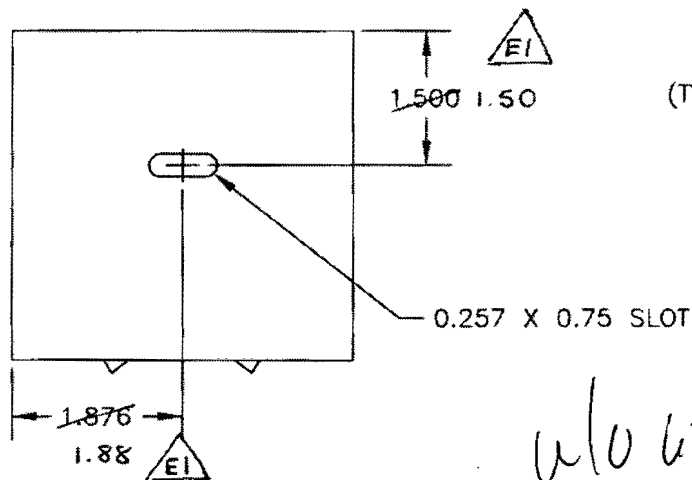
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	TITLE	SCALE
BW	CP	STEP SUPPORT BRACKET	1:2
CHECKED	APPROVED	DRAWING NO.	REV. E
KE	CP	D2362	SHEET 2 OF 3
DATE			
98.12.04			

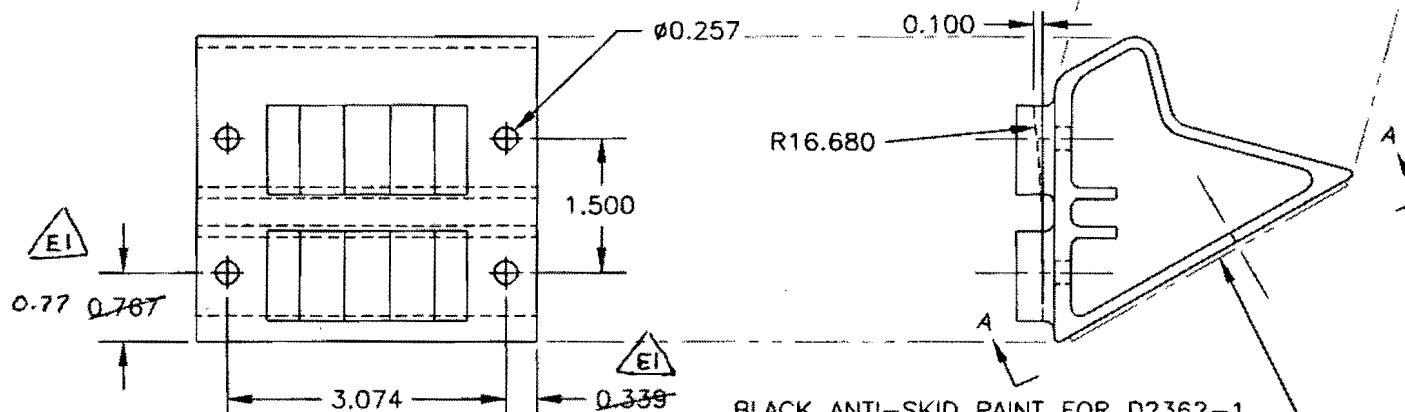
VIEW A-A



MACHINE TO
R1.100
(TYP 2 PLACES)

REMOVE TIPS
FROM CASTING
MAX 0.080

WLO 67215



BLACK ANTI-SKID PAINT FOR D2362-1
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
98.12.14
UNDER REVIEW

DESIGNER, DART AEROSPACE LTD
D23 BEFOR MANU FACTURE
CP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



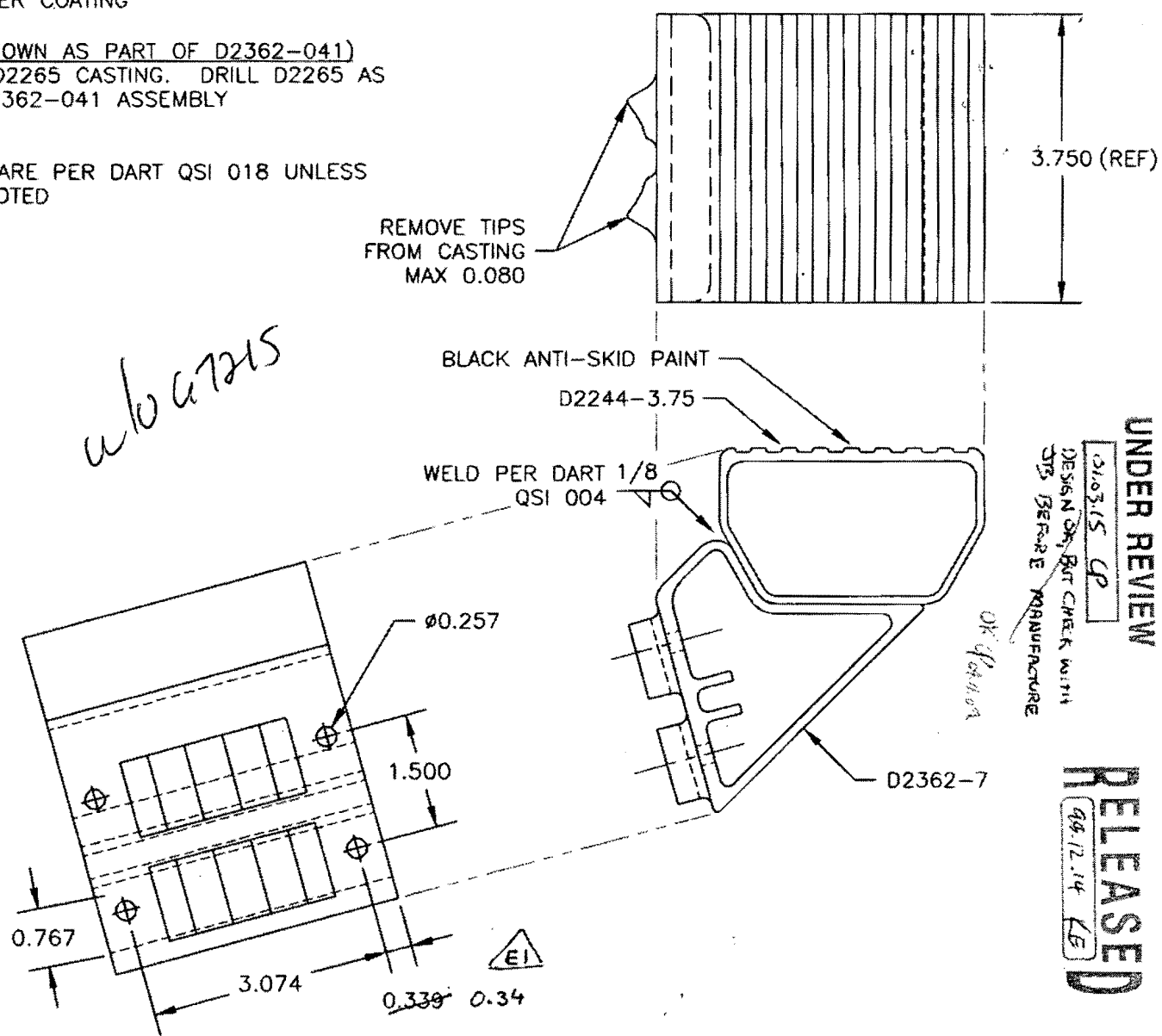
DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
BW	<i>CP</i>		
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2362	SHEET 3 OF 3
DATE 98.12.04		TITLE STEP SUPPORT BRACKET	SCALE 1:2

UNDER REVIEW

RELEASED
98.12.14 KE

2103/15 CP
DESIGN OK, BUT CHECK WITH
DTS BEFORE MANUFACTURE

OK *CP*



D2362-041 (SHOWN)
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PIANT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)
MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries